



**Work Order ID 86447**

June-29-12 7:57:42 AM

**\*86447\***

Page 2

Item ID: D4422-3

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Shim

Stop **\*NS2\***

Start Date: 6/29/12 Start Qty: 10.00

**\*10\***

Cust Item ID:

Required Date: 6/29/12 Req'd Qty: 10.00

**\*10\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC21- Final Inspection - Work Order Release

0.00

**\*130\***

QC

Memo

0.00

Quality Control

12/7/30  
ME  
12-06-29

# Picklist Print

June-29-12 7:57:41 AM

Page 1

Work Order ID: 86447

Parent Item: D4422-3

Parent Item Name: Shim

Start Date: 6/29/12

Required Date: 6/29/12

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP revA 11.06.30 new issue EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.063

Purchased

No

sf

505.6368

0.2443158

6061-T6 .063 Sheet

Location

Loc Qty

Loc Code

MAT021

121578

505.6368320

113608

0

116308

5.01556842

117285

67.544

119331

44.2

119802

5.94

120218

15.86

120866

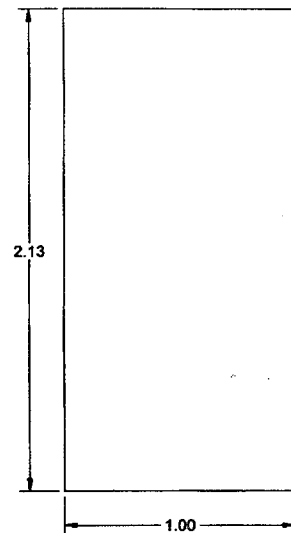
64.8126316

121805

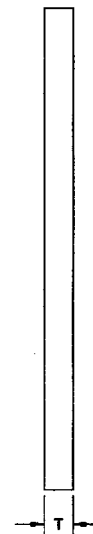
302.264632

0.2443158

10 FB 12-06-29



**D4422-X SHIM**



P/N	"T" THICKNESS
D4422-1	0.125
D4422-3	0.063

**NOTES:**

**1) MATERIAL:**

D4422-1: 6061-T6/T62 ALUMINUM SHEET, 0.125 THICK, PER QQ-A-250/11  
OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209  
REF DART SPEC M6061T6S.125  
OR  
6061-T6/T651/T6510/T6511/T62, 0.125 X 1.000, PER QQ-A-225/8  
OR AMS-QQ-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8 (OR AMS 4160)  
OR ASTM B211 OR ASTM B221  
REF DART SPEC M6061T88

D4422-3: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK, PER QQ-A-250/11  
OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209  
REF DART SPEC M6061T6S.063

**2) FINISH:** CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

**3) TOLERANCES:** PER DART QSI 018 UNLESS OTHERWISE NOTED

**4) UNITS:** INCHES UNLESS OTHERWISE NOTED

**5) BREAK SHARP EDGES:** 0.005 TO 0.010 MAX

**6) IDENTIFICATION:** IDENTIFY WITH DART P/N "D4422-X" AND B/N PER QSI 044 6.1

**7) WEIGHT:** D4422-1 = 0.01 lbs; D4422-3 = 0.01 lbs

*W/O 86447*

**RELEASED**  
2011-07-06

A	NEW ISSUE	MB	11.06.22
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.06.22		

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. <b>D4422</b>	REV. A
TITLE <b>SHIM</b>	SCALE NTS
<small>COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

